Date:

Monday, 10/30/2006 4:15:01 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 29227

: 10725

P.O. Number

: NA

This Issue Prsht Rev.

First Issue

Written By

Comment

Previous Run

: 10/30/2006

: N/A : 29007

S.O. No. : NIA

Type

: MACHINED PARTS

Now machined in house.

11.5500 f(s)

Drawing Revision Material

NG

Drawing Name

Part Number

Drawing Number

Project Number

Due Date

: N/A : 11/24/2006

: BUSHING

: D2652

: N/A

: D2652 REV A

Each

Additional Product

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description:

303 Round Bar 0.500"

1.0

2.0

3.0

4.0

5.0

M303R0500

Comment: Qty.: 0.0578 f(s)/Unit Total: Material:303 ss .500" Round Bar

(M303R0500)

Batch: M 102447

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

QC2

INSPECT PARTS AS THEY COME OF

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

Locheloy

Comment: SECOND

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and S Location:

4506/11/08

194

194

Page 1

Dart Aerospace Ltd

Dail Ae	rospace	Lla							
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -		
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes(No DQ	A: <u></u>	Date: _	06/11/08
		•			QA: N	/C Close	d:	_ Date: _	
NCR:		\	NORK ORD	ER NON-CONFORMA	NCE (NCF	()			
		Description of NC	Corrective Action		n Section B		cation	Ammrayal	Ammrayal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Approval Chief Eng	Approval QC Inspector
								,	
								·	

NOTE: Date & initial all entries

Date: User: Monday, 10/30/2006 4:15:01 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29227

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UD6/1/08

Dart Aerospace Ltd

DuitAc	Ospace	Ltu								
W/O:			WC	RK ORDER CH	IANGES					
DATE STEP		PRO	CEDURE CHA	NGE		Ву	Date (Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			ost vita							
									,	
Part No	:	PAR #:	Fault Cate	gory:	NC				_ Date: _ _ Date: _	
NCR:		V	VORK ORDI	ER NON-CONFO	PRMANCE					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign &	Verificat Section		Approval Chief Eng	Approval QC Inspector
			one, and	Office Ling		Bute				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29227
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	0.699				
0.060	+/-0.005	0.059				
Ø0.305	-0.002/+0.000	00.305				
Ø0.191	+0.005/-0.000	80.194	/			
Ø0.500	+/-0.010	XO. 499	/			
0.030 x 20°	+/-0.010	0.028820				
R0.010	+0.010/-0.000	RO.015	1			
				·		
A 100					** · · · · · · · · · · · · · · · · · ·	
					·	

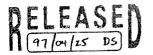
Measured by:	and	Audited by:	JF.	Prototype Approval:	N/A
Date:	06/11/04	Date:	06/11/04	Date:	NIA

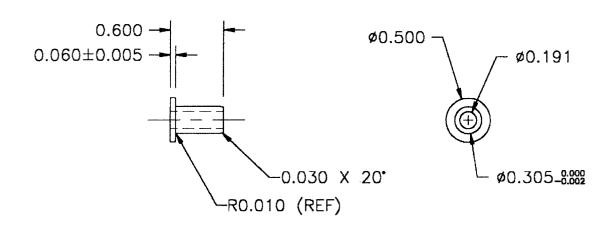
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	1





	DESIGN	DRAWN BY	DART AEROSPACE US	
-	CHECKED	APPROVED	DRAWING NO.	REV. A
	BW	101 BY	D2652	SHEET 1 OF 1
	DATE	<u>- •</u>	TITLE	SCALE
	97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE